

Work Order ID 88460-2

August-02-12 10:18:10 AM

88460

Page 1

Item ID: D3017-7

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lug

Start Date: 8/27/12

Start Qty: 4.00

4

Required Date: 8/27/12

Req'd Qty: 4.00

4

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/08/13

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3017

Rev B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3017

Dwg Rev: B

Prog Rev: B

4130 .600

2-Deburr

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

20

0

Jm 12-9-21

20

0

Jm 12-9-21

Work Order ID 88460

August-02-12 10:18:10 AM

88460

Page 2

Item ID: D3017-7 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lug
Start Date: 8/27/12 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 8/27/12 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 Smb 12-9-21 0.00				20			
130 *130* Brake NC Brake NC	NC BRAKE Memo 1-Deburr 2-Form as per Dwg D3017 using DT8598	0.00 0.00				6			SA 12/6/02
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 Smb 12-10-21 0.00				6			DAC 12/10/02

August-02-12 10:18:10 AM

Page 3

Accept

Setup Start *NS1*

Stop *NS2*

Cust Item ID:
Customer:

4

4

Reference:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
Number

Insp.
Stamp

150

0.00

150

Packaging

0.00

Packaging

Memo

Identify and bag with light oil (Vactra oil #2), then Stock
Location: *W/L*

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

160

Memo

0.00

QC

Quality Control

Picklist Print

August-02-12 10:18:10 AM

Page 1

Work Order ID: 88460

Parent Item: D3017-7

Parent Item Name: Lug

Start Date: 8/27/12

Required Date: 8/27/12

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP: B03.05.09ReformatKJ/RF

IPP Rev:C 08-04-11 now made on water jet DD verified by:EC

IPP RevB: as per

revB DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NS.049 4130 Sheet .049		Purchased	No			100	sf	3.8000	0.102	0.4294736			

2.25 ~~0.5~~

Aug 29-12

Location

MAT020

Loc Qty

3.8

Loc Code

11612

3.8

123049

123049

2.25 S.F.

ITEM No.	QTY	PART NUMBER	DESCRIPTION
1	X	D3017-041	BACK FRAME ASSEMBLY
2	1	D3017-1	TUBE
3	1	D3017-3	TUBE
4	1	D3017-5	TUBE
5	3	D3017-7	LUG
6	2	D3017-11	END CAP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 88460 MLJ

12/08/13

RELEASED
2010-02-02

B	REFORMAT DWG, -5 TUBE WALL THKNS REVD (A8-3) SHEET 3 & 4 ADDED TO CLARIFY DRAWING. RADIUS CHANGED FROM R4.00 TO R3.75 (B4-2, B2-2). HOLE SIZE CHANGED FROM Ø0.191 TO Ø0.257 (C6-3, C3-3)	JPH	10.01.13
A	NEW ISSUE	CP	01.05.15
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.01.13		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

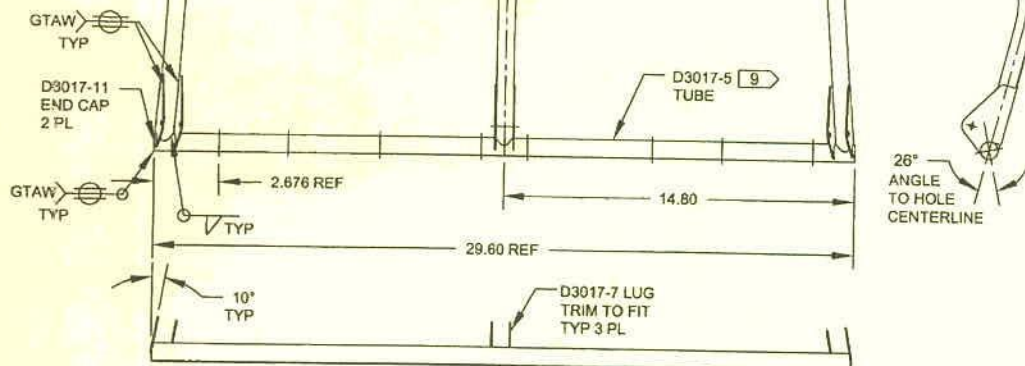
DRAWING NO. REV. B
D3017 SHEET 1 OF 4
TITLE SCALE
BACK FRAME ASSEMBLY NTS

COPYRIGHT © 2001 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD

D3017-041 BACK FRAME ASSEMBLY

NOTES:

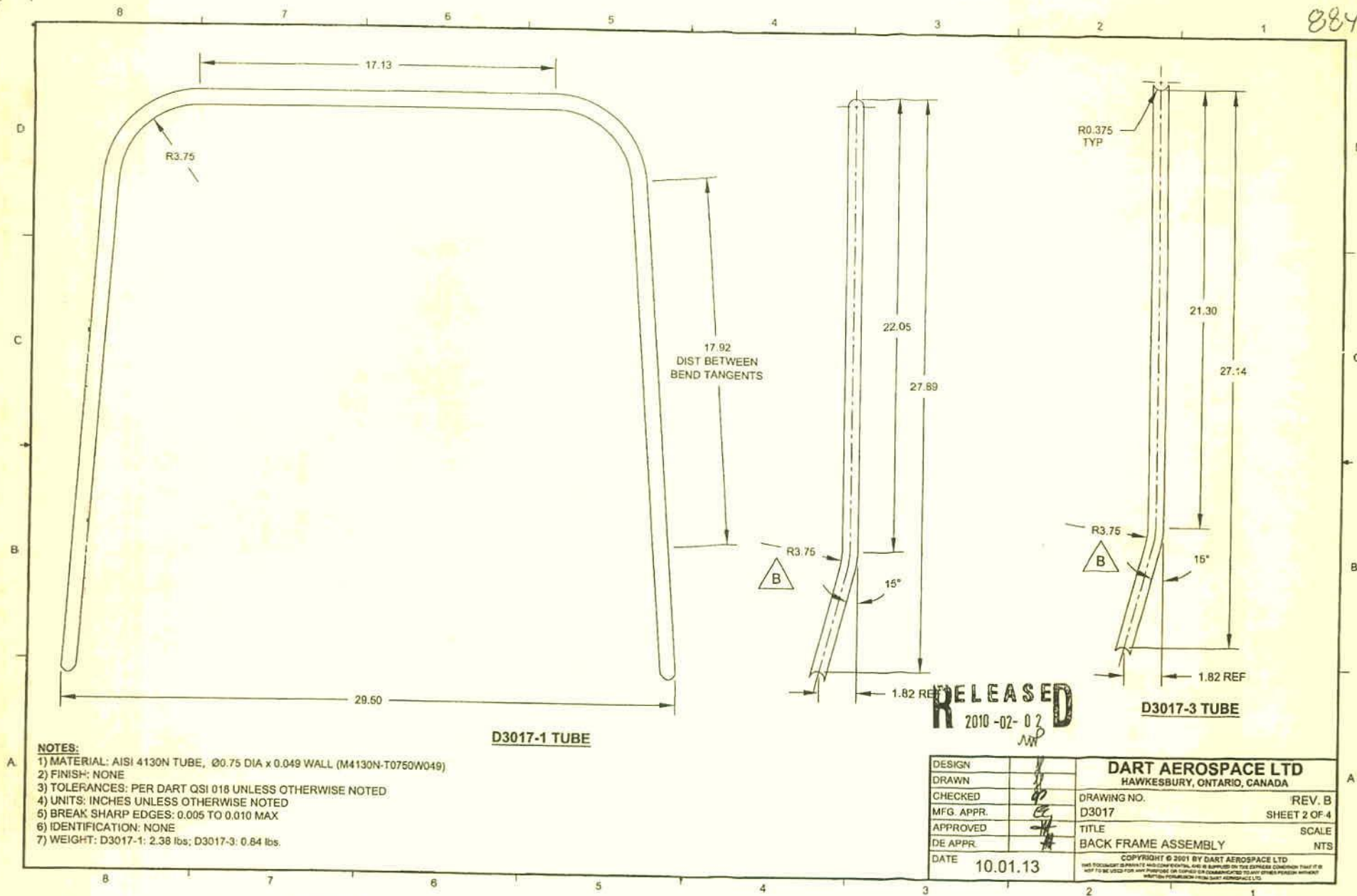
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3017-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.50 lbs
- 8) WELD PER DART QSI 004
- 9) ROTATE SO THAT PILOT HOLES ARE ANGLED AS SHOWN IN END VIEW.



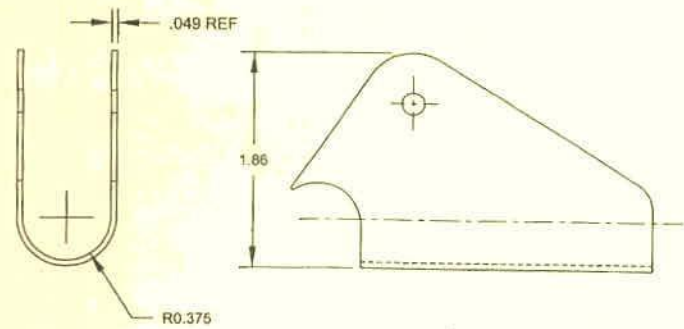
DRILL Ø0.128 HOLES TO LINE UP WITH D3023-1 BACK PANEL

26°
ANGLE
TO HOLE
CENTERLINE

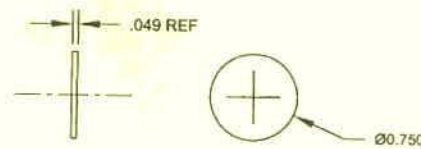
88460



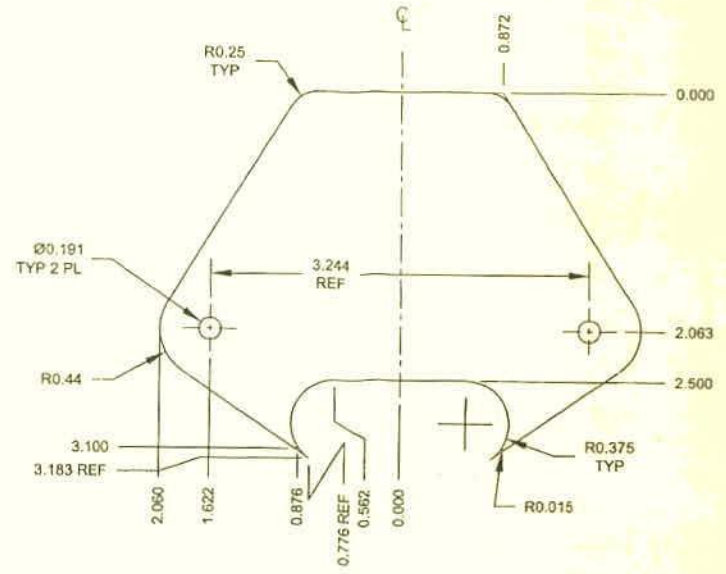
88460



D3017-7 LUG
BENDING DETAIL
MAKE FROM D3017-7F



D3017-11 END CAP



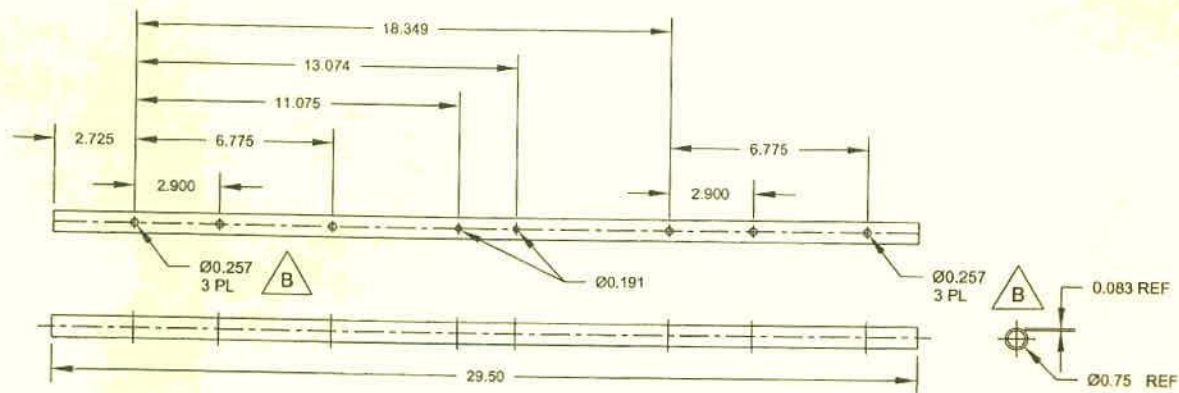
D3017-7F FLAT PATTERN
PART IS SYMMETRIC
ABOUT CENTERLINE

RELEASED
2010-02-02
AMP

- NOTES:**
- 1) MATERIAL: AISI 4130N SHEET, 16 GAUGE (M4130N-S049)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: -7: 0.12 lbs; -11: 0.01 lbs.

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3017	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BACK FRAME ASSEMBLY	N'S
DATE	10.01.13	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

88460



D3017-5 TUBE

RELEASED
2010-02-02
MP

NOTES:

- 1) MATERIAL: AISI 4130N TUBE, Ø0.75 DIA x 0.083 WALL (M4130N-T0750W083)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.89 lbs



DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3017	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BACK FRAME ASSEMBLY	N'S
DATE	10.01.13	COPYRIGHT © 2001 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR LOANED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

